

Work Order ID 72169

Tuesday, July 19, 2011 1:52:17 PM



Page 1

Item ID: D3508-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 7/19/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: 

Date: 7-19-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3508

Rev C

100



Waterjet

FLOW WATER JET

0.00

Memo

0.00

FLOW CNC Waterjet

304 . dcd

1-Cut as per Dwg D3508 ☐ Dwg Rev: e ☐ Prog Rev: C ☐ 2-
Debur if necessary

B11-8-9

(12)

110



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Quality Control

B11-8-9

120



QC

QC8- Inspect parts - second check

0.00

Memo

0.00

Quality Control

Subs/10

(712)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries




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Page 2

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Required Date:	7/25/2011	Req'd Qty:	8.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC	NC BRAKE	0.00							
Brake NC	Memo	0.00				(12)	2	11-08-12	
	1-Form on brake using DT8326 and DT8261 as per Dwg D3508 2-Form joggle as per Dwg D3508 Using DT8158								
140  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00				for			
150  Powdercoat	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powder Coating	Memo	0.00							
	START TIME: 7:45								
	FINISH TIME: 8:15								

W 117338

320012

OVEN TEMPERATURE:

12x 4 M 11/08/15

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Page 3

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Start Date: 7/19/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				12	4	11/08/15	
170 Packaging Packaging	Identify as per dwg & Stock Location: <u>F-P1</u> Memo	0.00 0.00				12	4	11/08/15	
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						11/8/15	

MF 11-08-15

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NOTE: Date & initial all entries

Picklist Print

Tuesday, July 19, 2011 1:52:23 PM

Page 1

Work Order ID: 72169

Parent Item: D3508-3

Parent Item Name: Wearplate




Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 06-06-20 JLM
IPP Rev:B Now SS as per Rev B 06-12-15 JLM
IPP Rev:C Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA  304/316 .040 Sheet		Purchased	No			100	sf	110.0630	0.734	6.181053	9, B11-9-8		

Location

Loc Qty

Loc Code

MAT020

110.063

116623

0.2

117550

9.363

117933

100.5

118400

118400

12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	72169
Description: Wearplate		Part Number:	D3508-3
Inspection Dwg: D3508 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.063	+/-0.010	2.064	X		V RBZ	
2.813	+/-0.010	2.809	X		V	
0.375	+/-0.010	-373	>		V	
5.625	+/-0.010	5.625	e		T RB1	
33.750	+/-0.010	33.756	s		T	
37.13	+/-0.030	37.13	x		T	
Ø0.188	+0.005/-0.001	.191	x		V	
0.300	+/-0.010	.306	p		V	
0.300	+/-0.010	.306	p		V	
0.038	+/-0.010	.035	2		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 11-8-9	Date: 11/08/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.15	New Issue	KJ/DD	

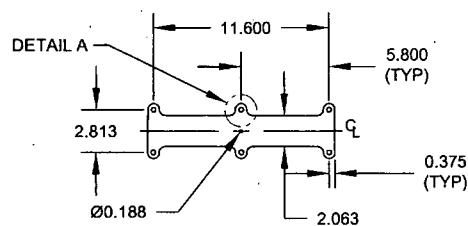
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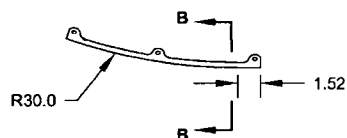
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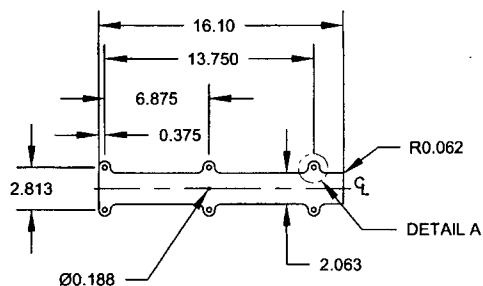
NOTE: Date & initial all entries



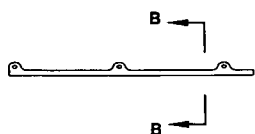
D3508-1 FLAT PATTERN



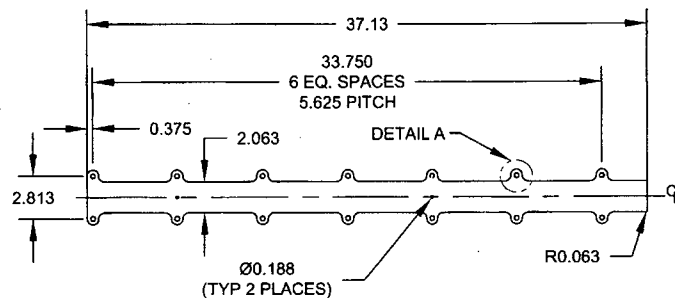
D3508-1 BENDING DETAIL
(MAKE FROM D3508-1F)



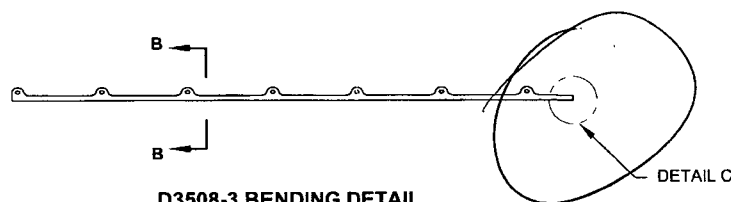
D3508-7F FLAT PATTERN



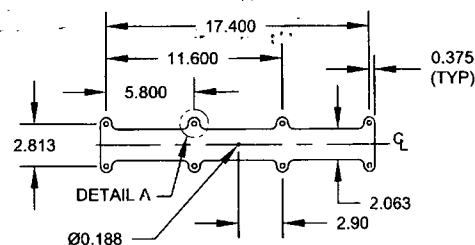
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(MAKE FROM D3508-7F)



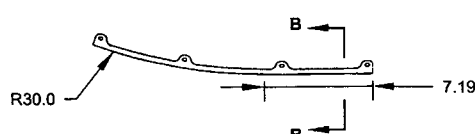
D3508-3 FLAT PATTERN



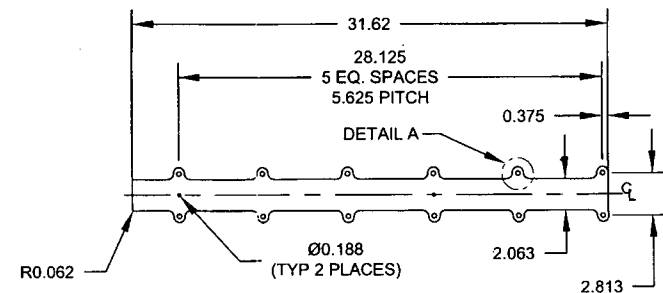
D3508-3 BENDING DETAIL
(MAKE FROM D3508-3F)



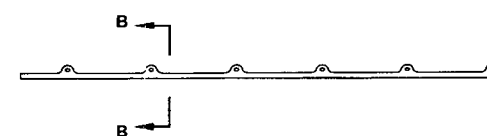
D3508-9F FLAT PATTERN



D3508-9F BENDING DETAIL
(MAKE FROM D3508-9F)



D3508-5 FLAT PATTERN



D3508-5 BENDING DETAIL
(MAKE FROM D3508-5F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.015
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs,
D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs
D3508-13 - 0.25 lbs

RELEASED
07-11-16

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMEND
WITHOUT NOTICE
WORK ORDER
NO. 72469

C	ADD -9/-11/-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN DRAWN	<i>[Signature]</i>	DART AEROSPACE USA, INC PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3508	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE	1:8
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

11-07-19

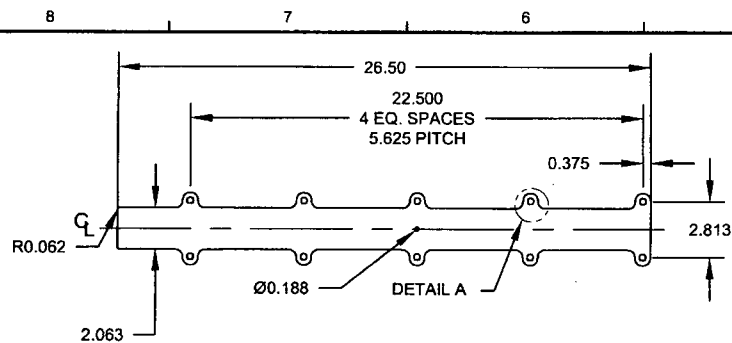
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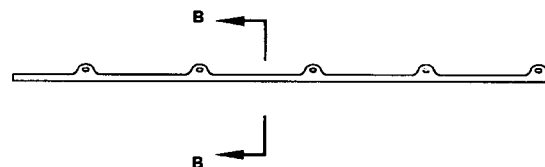
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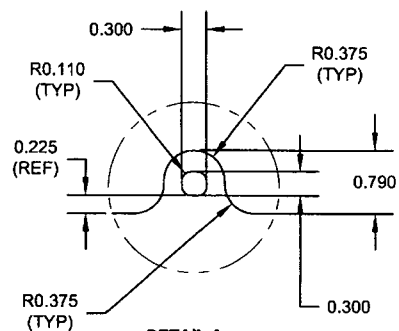
NOTE: Date & initial all entries



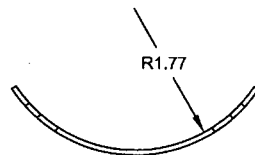
D3508-11F FLAT PATTERN



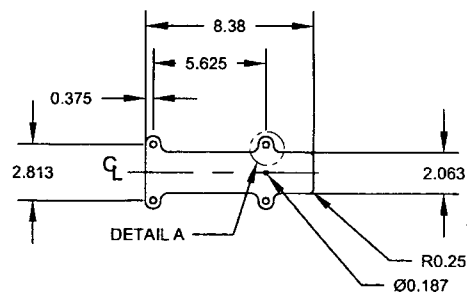
D3508-11 BENDING DETAIL
(MAKE FROM D3508-11F)



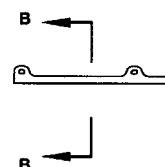
DETAIL A
(SCALE 2:3)



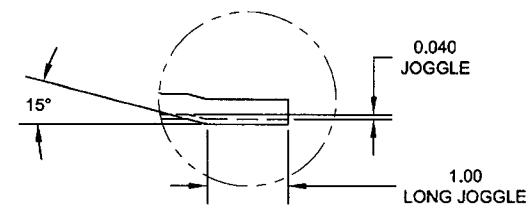
SECTION B-B
(SCALE 2:3)



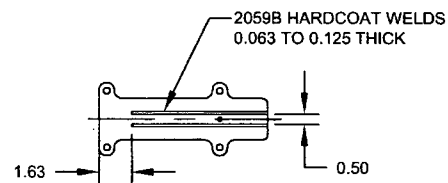
D3508-13F FLAT PATTERN



D3508-13 BENDING DETAIL
(MAKE FROM D3508-13F)



DETAIL C
(SCALE 1:2)



D3508-13 WELDING DETAIL

72169

RELEASED
07-11-16

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3508	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARPLATE	1:6
DATE	07.04.20	<small>COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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